

Date: Tuesday, 6/12/2007 3:00:56 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW LUG
Job Number : 32897	
Estimate Number : 11217	
P.O. Number : <i>N/A</i>	Part Number : D34041
This Issue : 6/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3404 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26775	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/19/2007 Qty: 24 Um: Each
Checked & Approved By : <i>[Signature] 07.06.12</i>	
Comment : Est Rev: A 05.09.01 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750X2500	304 BAR .750 X 2.5
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Comment: Qty.: 0.2406 f(s)/Unit Total : 5.7733 f(s)  
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick  
 (M304B0.750x02.500)  
 Identify for D3404-1  
 Batch: *104 933* \*Unable to enter *BC 07.07.07*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank: 2.750" long

*BC 07.07.07*

*24*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404  
 Dwg Rev: *B* Folio Rev: *AA*

2-Deburr

*J.L. / BC 07.07.07*

*24*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. / BC 07.07.07*

*24*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.M. 07/07/08*

*24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/07/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW LUG

Job Number: 32897

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

FC 07/07/08 (24)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(24)

Comment: FINAL INSPECTION/W/O RELEASE

2107/08

Job Completion



c207/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

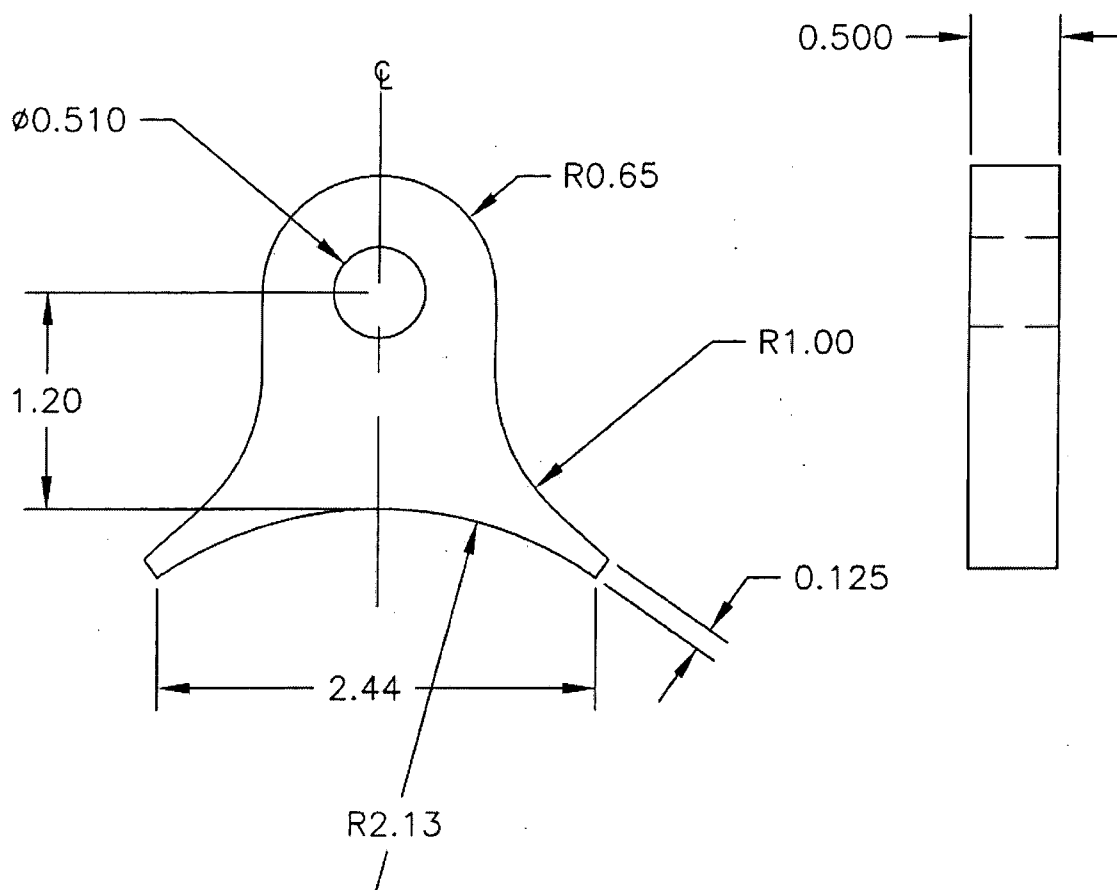
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3404	REV. B SHEET 1 OF 1
DATE 05.06.14		TITLE GHW LUG	SCALE 1:1
A	05.03.08	NEW ISSUE	
B	05.06.14	UPDATE M-SPEC	

**RELEASED**  
05-08-09 #1**D3404-1 GHW LUG**

- 1) MATERIAL: AISI 304/316 SS BAR  
(REF. DART SPEC. M304B0.750X02.500)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP CORNERS 0.03 TO 0.06
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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